

Work Order ID 50629 ✓

July 17, 2009 11:41:51 AM

Page 1

Item ID: D350-748-141TRN

Accept

Setup Start

Revision ID: D

Stop

Item Name: Crosstube Turning Detail

Start Date: 7/24/09 Start Qty: 1.00

Cust Item ID:

Required Date: 8/14/09 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start

QC: Date: SPC (Y/N): Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D350-748-141	Rev D

100

0.00



MORI SEIKI CNC LATHE LARGE

Mori Seiki

Memo

0.00

Mori Seiki CNC Lathe Large

1-Fill tube with sand & install plugs on both ends as per Folio FA648□2-Turn first side as per Folio FA648□3- File transition lines smooth.

a.m 09 - 09 - 14 @

110

0.00



QC1- Inspect dimensions to dimension sheet

QC

Memo

0.00

Quality Control

a.m 09 - 09 - 14 @

120

0.00



MORI SEIKI CNC LATHE LARGE

Mori Seiki

Memo

0.00

Mori Seiki CNC Lathe Large

1-Turn second side as per Folio FA648□2- File transition lines smooth.□3- Scribe Part & Batch as per Dwg D350-748-141

a.m 09 - 09 - 14 @

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 50629

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Page 2

Item ID: D350-748-141TRN

Accept



Setup Start



Revision ID: D

Stop



Item Name: Crosstube Turning Detail

Start Date: 7/24/09 Start Qty: 1.00



Cust Item ID:

Required Date: 8/14/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____

Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	QC1- Inspect dimensions to dimension sheet	0.00							
QC Quality Control	Memo	0.00							an 02 - 09 - 140
140 	QC8- Inspect parts - second check	0.00							
QC Quality Control	Memo	0.00							1 Ø - AWM9-10-07
150 	Large Fab	0.00							
Large Fab Large Fab	Memo	0.00							1 Ø - AWM9-10-07
	Grind machining marks								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 50629

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Page 3

Item ID:	D350-748-141TRN	Accept		Setup	Start	
Revision ID:	D				Stop	
Item Name:	Crosstube Turning Detail					
Start Date:	7/24/09	Start Qty:	1.00		Cust Item ID:	
Required Date:	8/14/09	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	Outsource process - Heat Treat	0.00							
Outsource1	Memo	0.00							
Outsource process - Heat Treat	Issue P/O: <u>10539</u> <input type="checkbox"/> Heat Treat to min 180 KSI As per Dwg D350-748-141 <input type="checkbox"/> (MIL-T-6736 OR AMS 2759-1C) <input type="checkbox"/> Sand Blast tube after Heat Treat <input type="checkbox"/> Possible Supplier: Vac Aero <input type="checkbox"/> Ensure Certificate of Conformity is attached								
170 	Receive & Inspect for Damage & Mat'l Certs	0.00							
Packaging	Memo	0.00							
Packaging	Ensure certificate of conformaty is attached								
180 	QC6- Inspect dimensions to drawing	0.00							
QC	Memo	0.00							
Quality Control									

10 09-10-7

10 09/11/06 @

8 09/11/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 50629

July 17, 2009 11:41:51 AM



Page 4

Item ID: D350-748-141TRN

Accept



Setup Start



Revision ID: D

Stop



Item Name: Crosstube Turning Detail

Start Date: 7/24/09 Start Qty: 1.00



Cust Item ID:

Required Date: 8/14/09 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190		0.00							
	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and stock in kanban rack	Location: <u>Back Hall</u>							<u>MB 09-11-23</u>
200									
	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

09/11/24 *[Signature]*

SMF 09-11-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July 17, 2009 11:41:50 AM

Page 1

Work Order ID: 50629

Parent Item: D350-748-141TRNRevD

Parent Item Name: Crosstube Turning Detail

Comments:

Start Date: 7/24/09

Required Date: 8/14/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6017-115RevA		Manufactured	No			110	Each	42.0000	1.0000			



Crosstube Material



am 09-09-14 @

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
LG	42	
32912	42	

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 50629
Description: Crosstube Assembly (AS350/355 High Fwd)		Part Number: D350-748-141
Inspection Dwg: D350-748-141 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.240	+0.005/-0.000	2.240	/			
	2.180	+0.005/-0.000	2.180	/			
	2.180	+0.005/-0.000	2.183	/			
	2.237	+0.005/-0.000	2.238	/			
	2.272	+0.005/-0.000	2.274	/			
	2.306	+0.005/-0.000	2.307	/			
	2.339	+0.005/-0.000	2.339	/			
	2.339	+0.005/-0.000	2.339	/			
	0.062	+/-0.010	0.062	/			
	4.26	+/-0.030	4.284	/			
	R0.063	+/-0.010	R0.063	/			
	R0.50	+/-0.030	R0.500	/			
SIDE B	2.240	+0.005/-0.000	2.240	/			
	2.180	+0.005/-0.000	2.180	/			
	2.180	+0.005/-0.000	2.183	/			
	2.237	+0.005/-0.000	2.238	/			
	2.272	+0.005/-0.000	2.274	/			
	2.306	+0.005/-0.000	2.307	/			
	2.339	+0.005/-0.000	2.339	/			
	2.339	+0.005/-0.000	2.339	/			
	0.062	+/-0.010	0.062	/			
	4.26	+/-0.030	4.282	/			
	R0.063	+/-0.010	R0.063	/			
	R0.50	+/-0.030	R0.500	/			
	110.27	+/-0.060	110.270	/			

Measured by: A.M.	Audited by: AWM	Prototype Approval: N/A
Date: 09.09.14	Date: 9-10-07	Date: N/A

Rev	Date	Change	Revised by	Approved
A	06.11.09	New Issue (P/O D350-748-101)	KJ/JLM	
B	07.10.24	Dwg Rev updated	KJ/EC/DD	

DART

RELEASED

06.10.31

DESIGN 90	DRAWN BY 90	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D350-748-141	REV. D SHEET 1 OF 3
DATE 06.10.31		TITLE CROSSTUBE (AS 350/355 HI FWD)	SCALE NTS
A	06.03.31	NEW ISSUE	
B	06.06.30	ADD D6017-115 & PRIME AND PAINT	
C	06.08.14	ADD CAD PLATING	
D	06.10.31	MAG. PARTICLE AND CAD PLATE AS MFD.	

QTY	P/N	DESCRIPTION
X	D350-748-141	CROSSTUBE ASSEMBLY (AS 350/355 HI FWD)
1	D6017-115	CROSSTUBE (OR D6015-125)
2	D3502-1	SUPPORT
2	D2856-400-710	ABRASION STRIP
1	AELS-1032-225	INSERT
1	AN960JD10	WASHER
2	MS21920-20	CLAMP (PER DART SPEC. M-MS21920-20)
1	MS27039-1-10	SCREW

D350-748-141 CROSSTUBE:

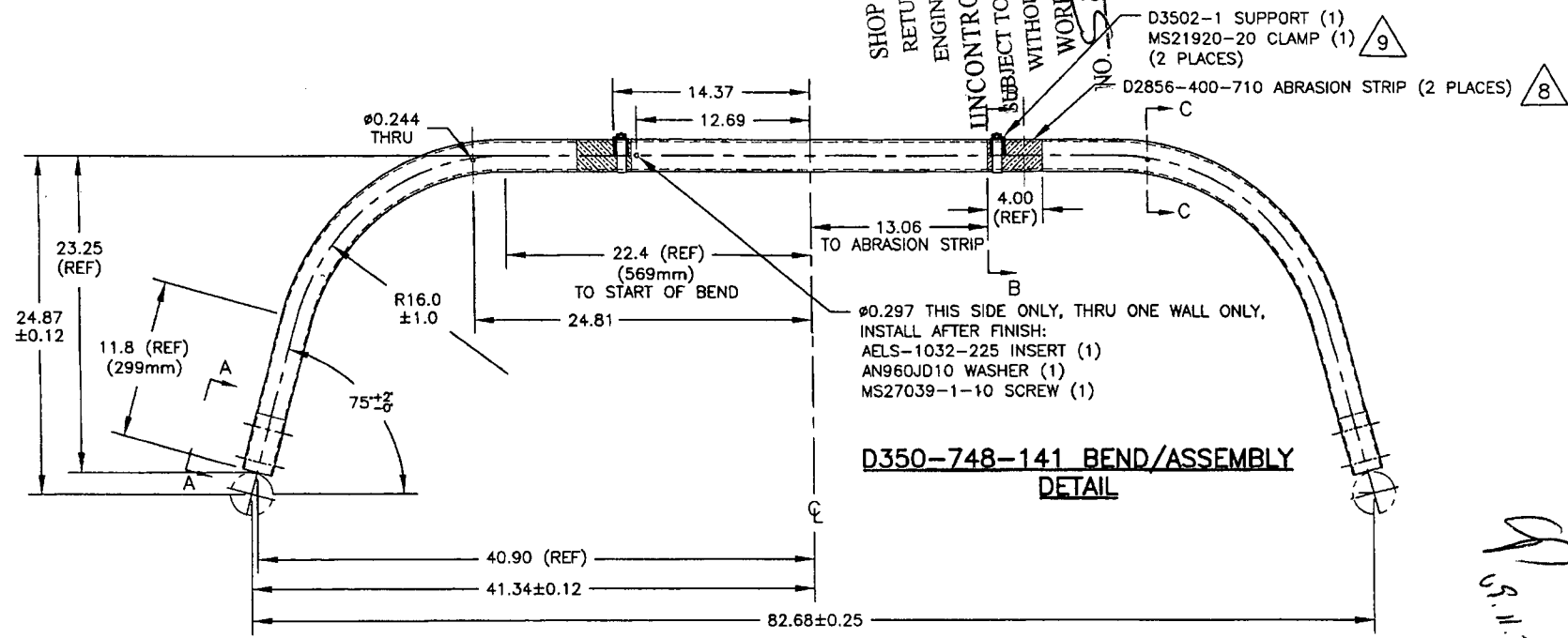
- 1) MATERIAL: MANUFACTURED FROM D6017-115 OR D6015-125
FINISHED LENGTH = 110.27±0.06
- 2) MACHINE PER MACHINING DETAIL ON PAGE 3. BLEND OUT ALL EDGES FROM MACHINING LONGITUDINALLY, TRANSITIONS SHOULD BE SMOOTH. NOTE: ALL HOLES ARE DRILLED AFTER BENDING.
- 3) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 4) BEND PROGRESSIVELY WITH A MINIMUM OF 7 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 5) HEAT TREAT TO MIN. 180 KSI PER MIL-T-6736 OR AMS 2759-1C AFTER TURNING
- 6) FINISH: MAGNETIC PARTICLE INSPECT PER DART QSI 038 4.2
CADMIUM PLATE PER AMS-QQ-P-416B, CLASS 1, TYPE II
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 7) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE. WHEN DRILLING HOLES EXTREME CARE MUST BE TAKEN AND CAREFUL DEBURRING PERFORMED TO ENSURE A CLEAN HOLE WITH NO CRACKING/CHIPPING/GROOVES.
- 8) INSTALL D2856-400-710 ABRASION STRIP WITH A GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D3502-1 SUPPORT, PER QSI 035.
- 9) TORQUE MS21920-20 CLAMPS 60 TO 80 IN-LB
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 11) ALL DIMENSIONS ARE IN INCHES
- 12) PART IS SYMMETRIC ABOUT CENTERLINE EXCEPT FOR Ø0.297 HOLE.

UNDER REVIEW09.02.05
Per per #09.001UNCONTROLLED COPY
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WITHOUT NOTICE
WORK ORDER
NO. 50629

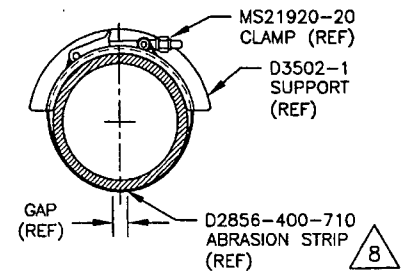
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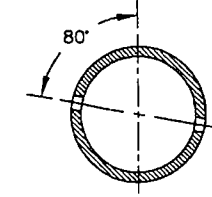
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NO. 50629



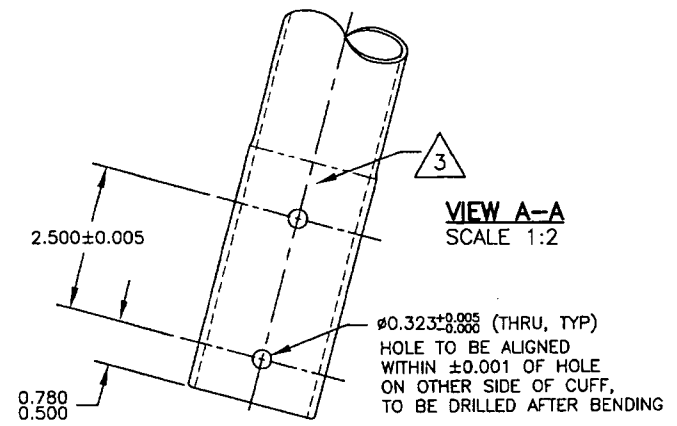
SECTION B-B
SCALE 1:2



SECTION C-C
SCALE 1:2



VIEW A-A
SCALE 1:2



OK
9.11.24

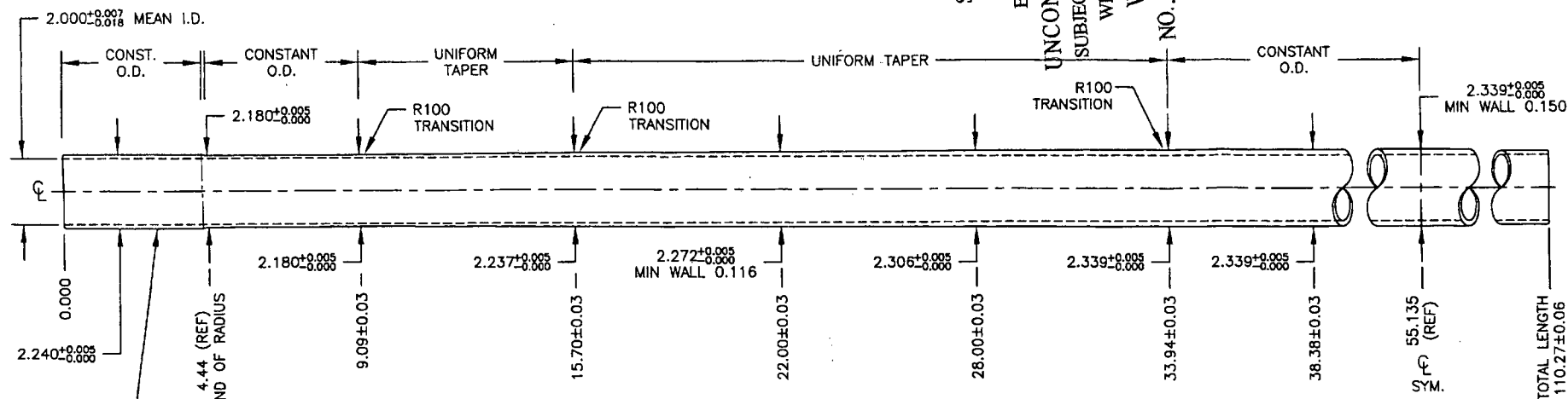
UNDER REVIEW
09.02.05

UNDER REVIEW
02.16.05

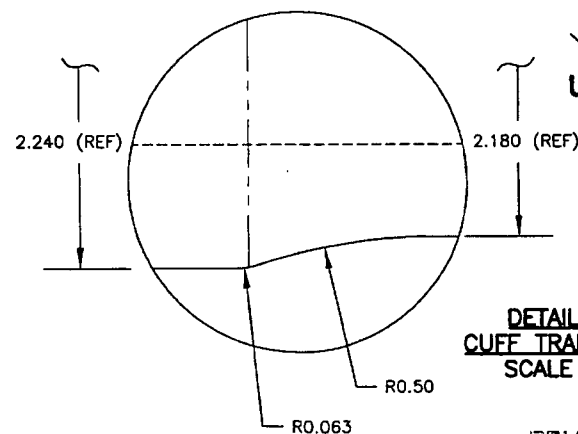
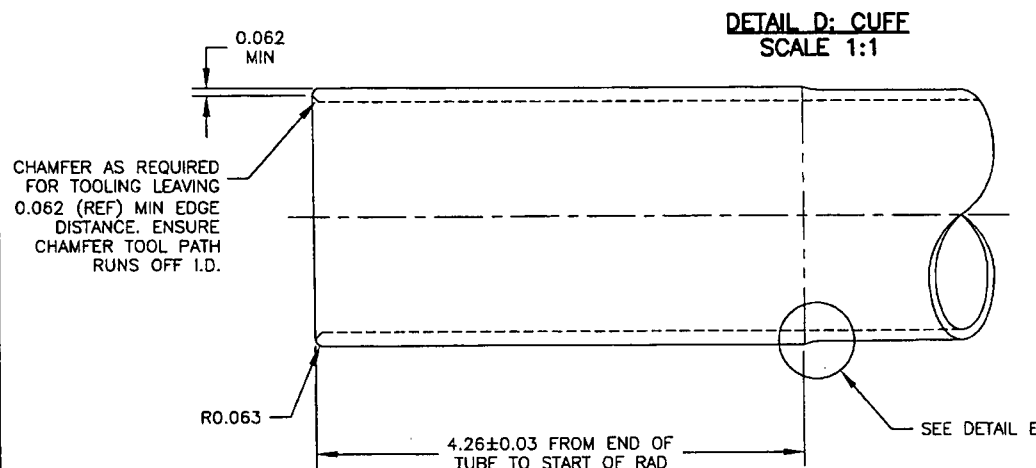
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		DATE		TITLE	SCALE	
		06.10.31		CROSSTUBE (AS 350/355 HI FWD)	1:8	

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WORK ORDER
NO. 50629



D350-748-141 MACHINING DETAIL



UNDER REVIEW
09.02.03

UNDER REVIEW
09.02.03

DETAIL E:
CUFF TRANSITION
SCALE 9:1

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06.10.31

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DESIGN 97	DRAWN BY 97	DART	DART AEROSPACE LTD. WINDSOR, ONTARIO, CANADA
CHECKED #	APPROVED #	DRAWING NO. D350-748-141	REV. D SHEET 3 OF 3
DATE 06.10.31	TITLE CROSSTUBE (AS 350/355 HI FWD)	SCALE 1:3	



VAC AERO
INTERNATIONAL INC.

RELEASE NO.

GST No.: R105468102

OAK 113616



HEAD OFFICE
1371 SPEERS ROAD, OAKVILLE, ONTARIO
CANADA L6L 2X5
TEL: (905) 827-4171 FAX: (905) 827-7489



2009 WYECROFT ROAD, UNIT B
OAKVILLE, ONTARIO
CANADA L6I 6J4
TEL: (905) 827-7377 FAX: (905) 827-1380



QUEBEC DIVISION
7450 RUE VÉRITÉ STREET, ST. LAURENT, QUÉBEC
CANADA H4S 1C5
TEL: (514) 334-4240 FAX: (514) 334-6269

11/03/20

MM / DD / YY

PAGE: 1

BILL TO: 1DAR01
DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON

SHIP TO: DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON

K6A 1K7

K6A 1K7

DATE SHIPPED	SHIP VIA	F.O.B.
11/03/2009		ORIGIN
CUSTOMER P/O No.	JOB No.	TERMS
10539		NET 30 DAYS

PART No.	DESCRIPTION	UOM	QTY ORD	QTY SHPD	TEST RESULTS
D350-748	-141/241	EA	12	12	
<p>Process Specifications: Procedure: 4353 HEAT TREATED TO 180 KSI MIN. PER DRAWING 100% HARDNESS CHECKED AS PER ASTM E-18 40/45 HRC MATERIAL: 4130</p> <p>4 PIECES B48603, B48604, B48605, B48606, P/N D350-748-241 8 PIECES B50621, B50622, B50623, B50624, P/N D350-748-141 B50621, B50622, B50623, B50625</p>					

100% HARDNESS TESTED

1.5 pc.

42/43 HRC



GP
09.11.23

I hereby certify that the material covered by this release note has been inspected and tested and conforms to all specifications relevant thereto in accordance with the conditions of the contract / or purchase order.

ON BEHALF OF VAC AERO INTERNATIONAL INC.



METAL TREATING INSTITUTE

Laura Labanov
Authorized Q.C. Inspector



VACUUM BRAZING · HEAT TREATING · SPECIAL PROCESSING · FURNACE EQUIPMENT
TURBINE COMPONENT OVERHAUL · PLASMA AND OTHER COATINGS